



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D2808

Job Sheet 204718



Part No: D2808

Job Qty: 30 pcs

DAS
21
9-89

Part Name: Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/18/19

Job Tracking No:

Due Date: 2/17/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP Rev:D 02.03.07 Now turned in house NG IPP Rev:E 07-12-18 RevB as per dwg ECN1048
DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Hardinge - 1	30 pcs		2/17/20	0.50	2.07	Hardinge - 1			BM 20-01-29
120	QC 8	30 pcs		2/17/20	0.00	0.00	QC 8 - 12			
							QC 8 - 14			
							QC 8 - 17			
							QC 8 - 20			
							QC 8 - 25			
							QC 8 - 3			
							QC 8 - 32			
							QC 8 - 33			
							QC 8 - 35			
							QC 8 - 39			
							QC 8 - 4			
							QC 8 - 44			
							QC 8 - 45			
							QC 8 - 49			
							QC 8 - 58			
							QC 8 - 8			
							QC 8 - 9			
							QC 8 - 68			
							QC 8 - 67			
							QC 8 - 1 (A)			
							QC 8 - 47			
							QC 8 - 40			
							QC 8 - 52			
							QC 8 - 23			
							QC 8 - 57			SBC 20/01/29
							QC 8 - 76			
							QC 8 - 61			
130	Handfinish - 1-1 Chemical-B4B	30 pcs		2/17/20	0.00	0.24	Handfinish - 1 - 1 - B4B			
							Handfinish - 1 - 2 - B4B			



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Container No: S251682



Part: D2808

Job No: 204718

Serial No/Batch: S251682

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/29/20

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SA JAN 30 2020

				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
140	QC 7	30 pcs	2/17/20	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
					QC 7 - 40
					QC 7 - 24
					QC 7 - 43

DAS
40
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FEB 13 2020

			QC 7 - 61	
			QC 7 - 81	
			QC 7 - 76	
			QC 7 - 79	
150 Packaging 3-1 - Stock - B4B	30 29 pcs	2/17/20	0.00 0.00	Packaging 3 - 1 - B4B Packaging 3 - 2 - B4B Packaging 3 - 3 - B4B ✓ Packaging 3 - 4 - B4B Packaging 3 - 5 - B4B Packaging 3 - 6 - B4B Packaging 3 - 7 - B4B Packaging 3 - 8 - B4B Packaging 3 - 9 - B4B Packaging 3 - 10 - B4B Packaging 3 - 11 - B4B Packaging 3 - 12 - B4B Packaging 3 - 13 - B4B Packaging 3 - 14 - B4B Packaging 3 - 15 - B4B Packaging 3 - 16 - B4B Packaging 3 - 17 - B4B Packaging 3 - 18 - B4B Packaging 3 - 19 - B4B Packaging 3 - 20 - B4B Packaging 3 - 21 - B4B Packaging 3 - 22 - B4B Packaging 3 - 23 - B4B Packaging 3 - 24 - B4B Packaging 3 - 25 - B4B Packaging 3 - 26 - B4B Packaging 3 - 27 - B4B Packaging 3 - 28 - B4B Packaging 3 - 29 - B4B Packaging 3 - 30 - B4B Packaging 3 - 31 - B4B Packaging 3 - 32 - B4B Packaging 3 - 33 - B4B Packaging 3 - 34 - B4B Packaging 3 - 35 - B4B Packaging 3 - 36 - B4B Packaging 3 - 37 - B4B
160 QC 21 - SA	30 29 pcs	2/17/20	0.00 0.00	QC 21 - SA - 21 ✓ QC 21 - SA - 70 QC 21 - SA - 53
Part Op 100 - (Hardinge) 1-Turn as per Folio FA256 (Measure D3387 Bracket .507" Dia for Proper press-fit) Descriptions: 120 - (QC8- Inspect parts - second check) 130 - (Chemical Conversion Coat per QSI005 4.1) 140 - (QC7-Inspect Chemical Conversion Coat) 150 - (Identify as per dwg & Stock Location: _____) LOCATION : GA 160 - (QC21- Final Inspection - Work Order Release)				DAS 80 9-89 FEB 13 2020 FA 127 21 3-50
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.625	6061-T6 Round Bar .625"	1.5900 ft (.053 ea)	100-Hardinge - 1	S243110
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M6061T6R0.625	2	26	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.191inches + 0.005 - 0.000	0.196 0.191	0.191	VERN PJ-05
2	Spacer	0.313inches + 0.005 - 0.000	0.318 0.313	0.313	VERN
3	Spacer	0.507inches + 0.001 - 0.000	0.508 0.507	0.5073	MIC FL-01
4	Spacer	0.641inches $\pm$ 0.010	0.651 0.631	0.645	VERN
5	Spacer	0.359inches $\pm$ 0.010	0.369 0.349	0.357	VERN
6	Spacer	0.040inches $\pm$ 0.010	0.050 0.030	0.045	VERN
7	Spacer	45.000Degrees $\pm$ 0.000	45.000 45.000	45°	GAUGE

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐						
Date :	Sequence #:	QTY Affected :		MRB (QSI042)				
Description Work Order Deviation			Disposition					
						Completed By		
						Lead hand / Supervisor		
						QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread						
Other/Details:								